

Date: Tuesday, 26/08/2008 10:41:50 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET LID ASSEMBLY		
Job Number	: 40584B		Part Number	: D2512		
Estimate Number	: 10207		Drawing Number	: D2512		
P.O. Number	:		Project Number	: N/A		
This Issue	: 26/08/2008		Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: 17/07/2008		Due Date	: 05/08/2008		
Previous Run	: 39529B		Qty:	1	Um:	Each
Written By	:		Comment	:		
Checked & Approved By	:		Comment	:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	
<b>Comment:</b> Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s) Pick: ✓ 3/4"x3/4" 304/316 SS tube .063" wall Batch: <u>21108846</u> <span style="float: right;">JL 08/09/03</span>			
2.0	D31663	Basket Hoop	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: ✓ Qty Part Number Description Batch 1 D3166-3 Basket Hoop <u>B10624</u> <span style="float: right;">SAO 08/08/12 ①</span>			
3.0	D2506	Label Plate	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: ✓ Qty Part Number Description Batch 1 D2506 Label Plate <u>B 39457</u> <span style="float: right;">JL 08/09/02</span>			
4.0	D23271	Spacer Bushing	
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: ✓ Qty Part Number Description Batch 2 D2327-1 Bushing <u>B 40390</u> <span style="float: right;">JL 08/09/01</span>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 40584B		Part Number: D2512
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	D22321 	Basket Hinge 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick: ✓ Qty Part Number Description Batch 2 D2232-1 Hinge plate <i>B 39454</i>		<i>SS 08/09/02</i>
6.0	D2581 	Mounting Bracket 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick: ✓ Qty Part Number Description Batch 2 D2581 Mounting Bracket <i>B 40086</i>		<i>SS 08/09/02</i>
7.0	M304EX07516F 	Expanded Metal Flat SS 
Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)		
Pick: ✓ Qty Part Number Description Batch 18 sf M304EX0.75-16F Expanded Metal <i>M 108830</i>		<i>SS 08/09/03</i>
8.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		
1-Cut 3/4" x 3/4" square tubing as per Dwg D2512 ✓		
2-Cut (4) D2236 From D3166-3 ✓		<i>SAD 08/08/29 ①</i>
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305 ✓		<i>M 08/09/03</i>
5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required ✓		<i>SS 08/09/03</i>
9.0	QC9 	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION <i>P 0809-04 K 0809-04</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 40584B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC6 DIMENSIONAL CHECK



*S. oelos (X)*

Comment: DIMENSIONAL CHECK

11.0 POWDER COATING POWDER COATING



*m/08523*

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

*2:30*

OVEN TEMPERATURE:

*400°*

FINISH TIME:

*3:00*

2ND COAT:

START TIME:

*3:25*

OVEN TEMPERATURE:

*400°*

FINISH TIME:

*3:55*

*F/L 08/09/08 ①*

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



*①*

Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 *w/w* Batch: *m/07892*

*F/L 08/09/08*

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*E/F 08/09/10 a*

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *6-A*

*E/F 08/09/10 ②*

15.0 QC21 FINAL INSPECTION/W/O RELEASE



*08/09/11 ③*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u 08.09.10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

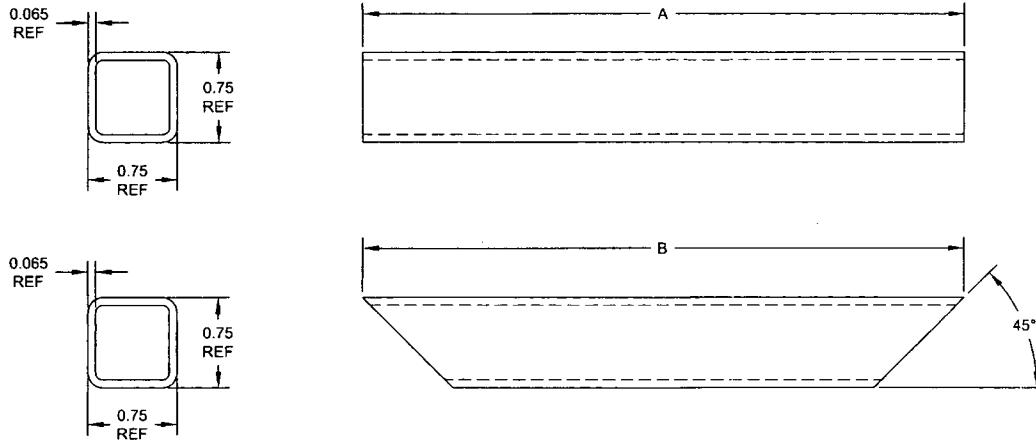
8 7 6 5 4 3 2 1

### PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

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08-08-21/17



E

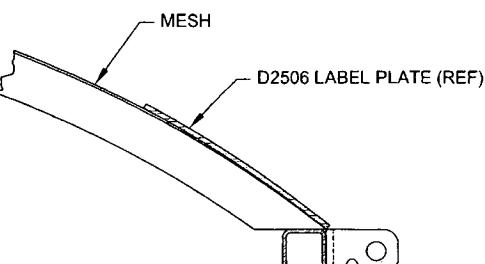
**D2512-1/-3/-5/-7 NOTES:**

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3. ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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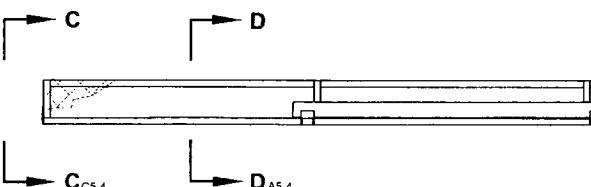
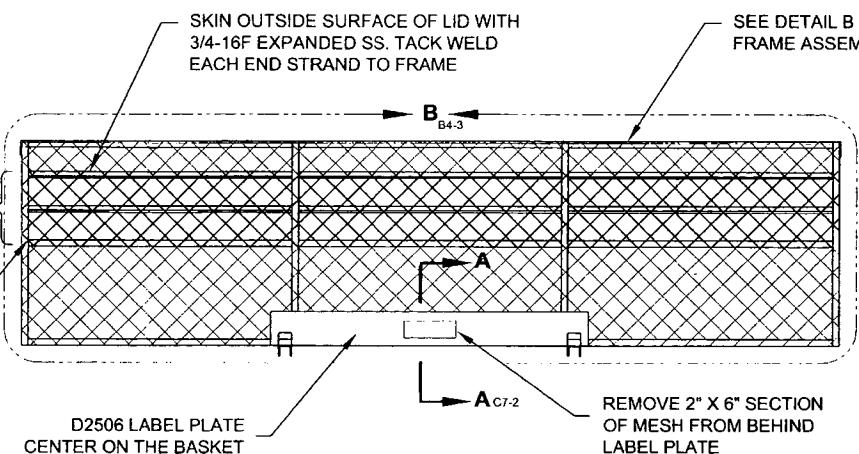
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SECTION A-A<sub>B3-2</sub>  
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED



E

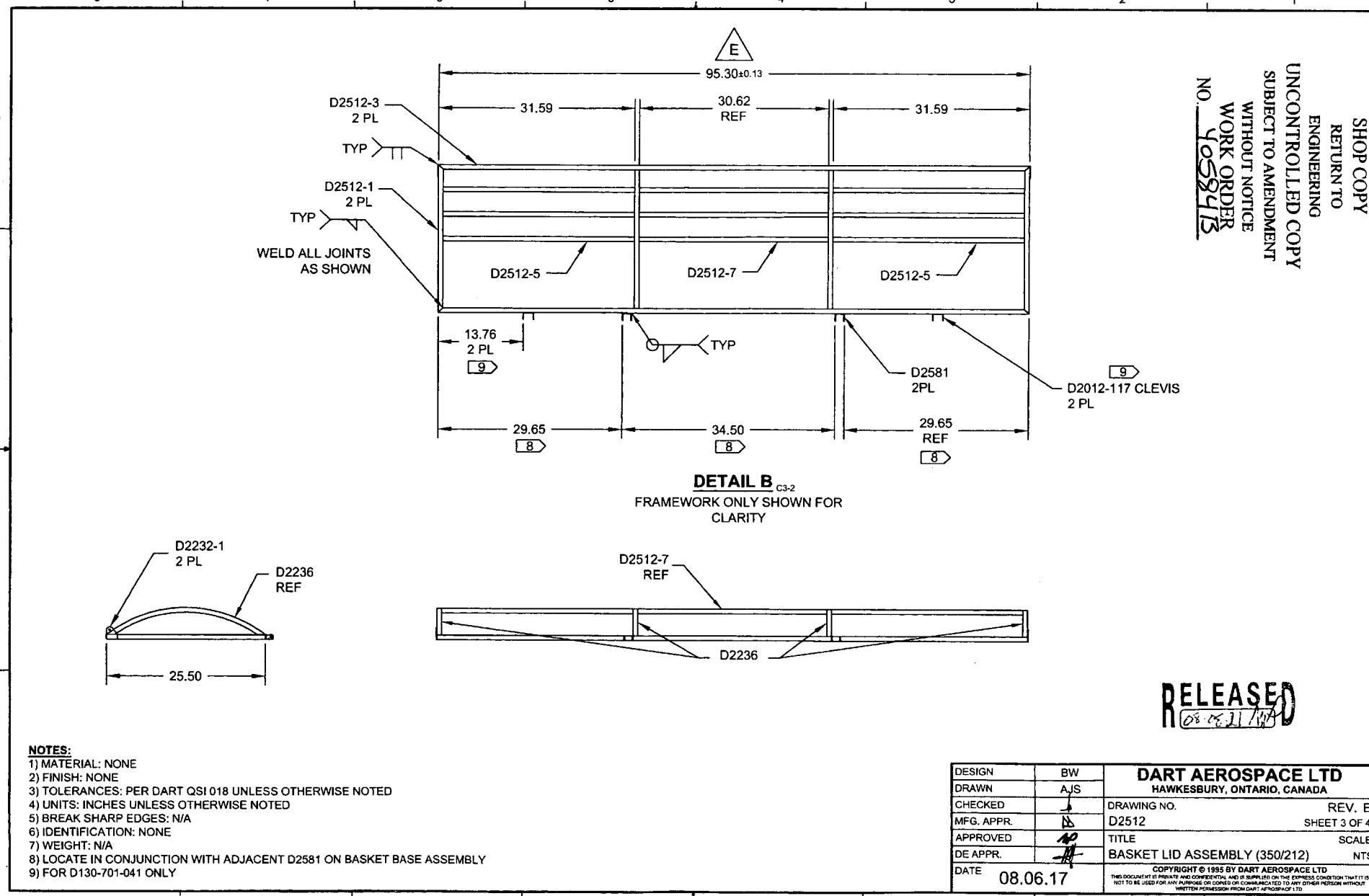
**D2512 BASKET LID ASSEMBLY NOTES:**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

RELEASED  
(05-05-21)

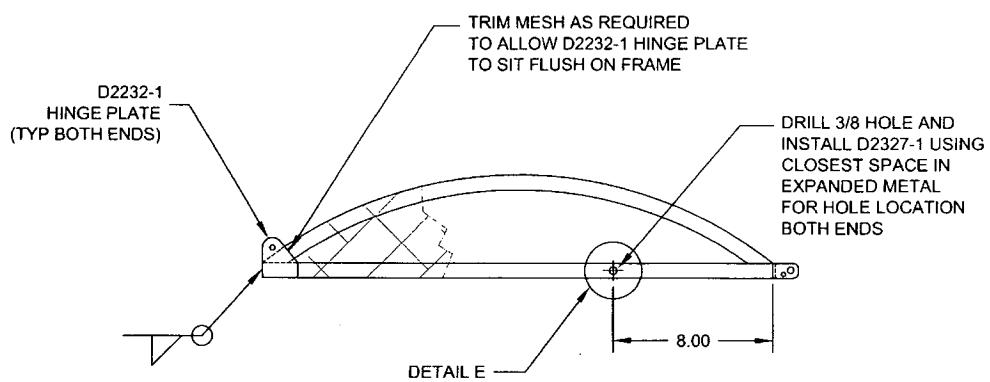
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
		D2512	SHEET 2 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY (350/212)	NTS
DE APPR.			
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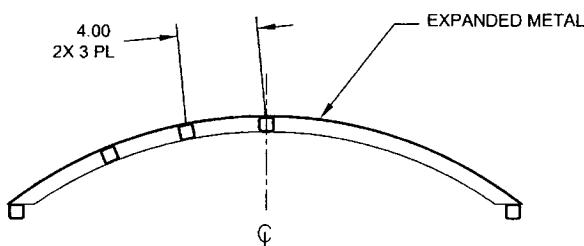


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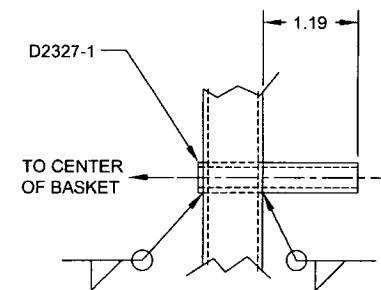
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NO. 4058413



VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

RELEASED  
*08-21-13*

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AA</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>AA</i>	D2512	SHEET 4 OF 4
APPROVED	<i>AA</i>	TITLE	SCALE
DE APPR.	<i>AA</i>	BASKET LID ASSEMBLY (350/212)	NTS
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